Work Orde	er ID 106647		*106	6647*							Page 1	
Item ID: Revision ID:	D3926-1		Accept	*N900	040	100] * :	Setup	Start	*N	S1*	
	Wedge								Stop	*N:	S2*	
Start Date:	9/06/13 Start Qty: 8.	oo *8*		Cust Item II	D:							
Required Date:	9/11/13 Req'd Qty: 8.	⁰⁰ * 8 *		Customer:								
Reference:							_	_	5			
Approvals:	Process Plan: MLJ	Date: 17-09-13	. Tooling:	Da	te:		ŀ		Start	*N	R1*	
	QC:	_		Da	te:				Stop	*N	R2*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr											
D3926	Rev A											
100			0.00				<i>•</i>					
100 Waterjet FLOW CNC Waterjet UHMW 1"	Dwg I	as per Dwg D3926 Rev:A	0.00				_8_	<	<u> </u>		Jm13-10-	-09
	2-Deb	ourr if necessary										
110	QC2- Inspect parts	off machine FAI/FAIB	0.00				0				7 0 10	~0
*11 0 *	Memo)	0.00				8		3		Jm 13-10	-0-

Quality Control

			DQA:	Date:
NCR: Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		

										QA Closed:	Dat	e:
Work Order	֥				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No	o				Rework Scrap Use-as-is	Th	Skid-t Machin	ning	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR No	0				Work Order Update	J	Large	Fab	Composite	J	Supplier	
Root				Descri	ption of work order update	Initia	al	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training												
Unapproved		<u> </u>	1		F	AULT CA	L ATEGORY				<u> </u>	
Landin	g Gear				General							
-	Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped at n Strip in		O/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short	Insp Inst Ma Mis Mis	dware pection Incorructions In intenance labeled read	complete,	/Unclear	Ovalized Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
-	Ripples in		Evtrusia	<u> </u>	Drill Holes Drawing	Offs	set : of Calibrat	tion			<u> </u>	
-	Torque W Turning S			" ├	Finish	\blacksquare	of Sequen			· · ·		
<u> </u>	Wave/Tw				Folio	\vdash	:side Dimer					

Work Ord September-11-1				*106	6647*						Page 2
Item ID: Revision ID: Item Name: Start Date:	D3926- Wedge 9/06/13	Start Qty: 8.00 Req'd Qty: 8.00	*8*	Accept	*N900		100) * 5	etup Sta Sto	I W.	S1* S2*
Reference:		req a Viy. 8.00	*8*		Customer:		_	F	tun Sta	rt 🕹 🛦 🛙	D4*
Approvals:		s Plan:	Date:	_		nte:			Sto	1/1	R1" R2*
Sequence ID/ Work Center I 120 *120 *120 *120 *120 QC Quality Control	D	Operation Description QC8- Inspect parts - second	ond check	Set Up/ Run Hours 0.00 DAS 0.00 27 9-89	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*130 *130* Small Fab Small Fab		Memo 1- Deburr i	inecessary	0.00	\						
140 *140* QC Quality Control		QC5- Inspect part comp	leteness to step on W/O	0.00	DAS 27 9-89						·

NCR: Yes /	No	WOR

DQA:

Date:

NCR: Y	'es	/ No				WORK ORDER NON-C	CONF	ORN	MANCE / UP	DATE	QA Closed:	Dat	te:
Vork Orde	, ė.					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS	
Part N	•					Rework Scrap		ı	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Quality
NCR N	lo.					Use-as-is Work Order Update	<u> </u>		noforming Large Fab	Finishing Composite	Rec/stol	re/Packaging Supplier	
Root					Descri	ption of work order update	Initi	ial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	n QC Inspector
oc/Data						,							
quip/Tooling								- 1					
perator						•							
laterial													
etup								İ					
ther													
rocess													
upplier													
raining													
napproved													
							AULT C	CATE	GORY				
Landi	ng (Gear				General					_	1	·
		Bending				Bend	\vdash	ain		_	Ovalized		Pressure/Forced
		Centre No	ot Concer	itric to (D/S	BOM/Route	На	ırdwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	Ins	specti	on Incomplete	L	Part Incorre	ct	Weld
		Crushed/0	Crimped			Burrs	Ins	struct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination	Шм	ainte	nance	<u></u>	Part Moved		
		Heat Trea	t			Countersink	Мі	islabe	led		Positioned V	Vrong	_
		Inspection	n Strip in	Tube		Cut Too Short	Мі	isread	Í		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes	Of	fset					
		Torque W	aves in E	xtrusior	1 [Drawing		ut of C	Calibration				
		Turning Se	equence			Finish	Ou	ut of S	Sequence				
		Wave/Tw	ist in Tuk	e		Folio	Ou	utside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord September-11-1				*106	6647*							Page 3
Item ID: Revision ID:	D3926-1			Accept	*N900	n 4n	100	i t	Setup		*NS	2 1
Item Name:	Wedge									Stop	*N.	32 *
Start Date:	9/06/13	Start Qty: 8.00	*8*		Cust Item I	D:						
Required Date	: 9/11/13	Req'd Qty: 3.00	*8*		Customer:							
Reference:			• •									
Approvals:	Process P	Plan:	Date:	Tooling:	Da	ate:				Start	"IZIF	₹1*
					Da	ate:				Stop	*NF	₹2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
150		Identify as per dwg & St	ock Location: <u>5†20</u> 3	0.00							DAS	
150 Packaging		Memo		0.00				8			9-89	13-10-
Packaging												
160		QC21- Final Inspection	- Work Order Release	0.00				ſ.	60		21.1	

0.00

Memo

160

Quality Control

13/10/10. Just 10-10

DQA:

Date:

NCR: Y	es	/ No				WORK ORDER NON-C	CON	FORN	/IANCE / UPI	DATE			
											QA Closed:	Date	·
Work Orde	r:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	,
Part N	o.					Rework Scrap			Skid-tube // Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
			***************************************			Use-as-is]		oforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o					Work Order Update	[]]		Large Fab	Composite	_	Supplier	
Root					Descri	ption of work order update	ln	itial	Act	tion	Sign &		
Cause	\bot	Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data	\perp												
quip/Tooling													
perator	_												
/laterial		,											
etup	\Box	<u>.</u> .											
Other		1.17			:								
rocess	╝												
upplier													
raining													
Inapproved													
						F.	AULT	CATE	GORY	<u></u>			
Landin	g G	iear			<u></u>	General					_	,	
		Bending				Bend	\square	Grain		<u></u>	Ovalized		Pressure/Forced
		Centre No	t Concer	itric to	O/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct	Weld
[Crushed/0	Crimped			Burrs		nstruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Ī		Cuffs				Contamination		Mainte	nance		Part Moved		
Ī		Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	_
Ţ	\neg	Inspection	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
Ţ		Torque W	aves in E	xtrusio	n	Drawing	П	Out of C	Calibration				
ļ	_	Turning So				Finish	П	Out of S	equence				•
Ì	\dashv	Wave/Tw		e e]	Folio	П	Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1/

Work Order ID:

106647

Parent Item:

D3926-1

Parent Item Name:

Wedge

Start Date: 9/06/13

Required Date: 9/11/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
MUHMWB10 UHMW 1" Black		Purchased	No			100	sf	1,005.6282	0.3609	3 .039157 6 3.5		Jr	13:10:09	
							-	C 1						

Location	Loc Qty	Loc Code	
MAT019	1005.628179		
121278	9.62817947		ALL PROPERTY OF THE PARTY OF TH
122575	47.6		
123229	53		
123704	63.8		
123949	6.96		
124382	197.12		
124758	17.52		
125137	210		
m126748	400		126748

			,						DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFO	ORN	MANCE / UPDATE	QA Closed:	Date:	
					DISPOSITION			AGAINST DE			
Work Orde	:r:	-		<u> </u>	Rework	ı		Skid-tube Crosstube		Water Jet	Engineering
Part N	0.				Scrap			Machining Small Fab	Pro	d. Eng. Coor.	Quality
NCR N	lo				Use-as-is Work Order Update	Th		oforming Finishing Large Fab Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initia	al	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	Eng	Description	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling							İ	•			
Operator											
Material [!		
Setup											
Other											
Process											
Supplier		i									
Training						ļ					
Unapproved			<u> </u>								
<u> </u>						AULT CA	ATEC	GORY			
Landir	ng Gear				General				1	Γ	1 . :
	Bending				Bend	Gra	ain		Ovalized	<u> </u>	Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	${f oxdot}$	dwa		Over/Under	 	Temperature/Cure
ļ	Cracks			<u> </u>	Broken/Damaged	—		on Incomplete	Part Incorre		Weld
	Crushed/	Crimped			Burrs	$\boldsymbol{\vdash}$		ions Incomplete/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	*		_	Contamination	∐ Ma	inte	nance	Part Moved		
'	Heat Trea	at		1	Countersink	Mis	labe	led l	Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	106647
Description: Wedge	Part Number:	D3926-1
Inspection Dwg: D3926 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.04	+/-0.030	1.050	-		V	Jamo,
1.50	+/-0.030	1.496"	~		ν	
1.50	+/-0.030	1.490"	_		V	
1.75	+/-0.030	1.742	-		∨'	
2.00	+/-0.030	1.986"	_		V	
2.92	+/-0.030	2.92	_		V	
1.00	+/-0.030	1.000"	_		V	
0.25	+/-0.030	0.563	_		V	
0.25	+/-0.030	0.259"	-		V	*
3.71	+/-0.030	3.71"	_		V	
1.00	+/-0.030	1.004"	_		V	٠.
14.01	+/-0.030	14.01"	-		T	JAMO6
	······································					
						·
			DAS			

			6-1			
Measured by: Jm		Audited by: 9-89		Prototype Approval:	N/A	
Date:	3-10-09	Date:	13/109	Date:	N/A	

Rev	Date	Change	Revis	ed		Approved
Α	09.09.17	New Issue		CFF	_	
				771		



